

Work Order ID 81345

81345

Page 1

March-13-12 1:34:43 PM

Item ID: D3508-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate

Stop

NS2

Start Date: 13/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 12/03/13 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: L 2-
Deburr if necessary

B12-3-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/2/13/14

12

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 12.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 12/04/02

(12)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

SB 12/04/02

(12)

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:15

OVEN TEMPERATURE:

m117 338

7:45 FINISH TIME:

320°F

12 & (OP) 12/04/03

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Page 3

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 13/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12 BR 12-4-3.

170

Identify as per dwg & Stock Location: **FP1**

0.00

170

Packaging

Memo

0.00

Packaging

12 BR 12-4-3.

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/3

12-04-3

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NOTE: Date & initial all entries

Picklist Print

March-13-12 1:34:48 PM

Page 1

Work Order ID: 81345

81345

Parent Item: D3508-11

D3508-11

Parent Item Name: Wearplate

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	163.6165	0.5887	7.436211			

M304S20GA

304/316 .040 Sheet

**

1812-3-29

Location	Loc Qty	Loc Code
MAT020	163.6165	
116623	0.2	
117933	27.3442	
118400	21.1723	
118964	36.5	
119346	29.8	
120604	48.6	

20604

12

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81345
Description: Wearplate		Part Number:	D3508-11
Inspection Dwg: D3508	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.069	1		✓ IB02	
2.813	+/-0.010	2.814	✓		✓	
0.375	+/-0.010	.377	2		✓	
5.625	+/-0.010	5.625	1		T H301	
22.500	+/-0.010	22.500	✓		T	
26.50	+/-0.030	26.50	✓		T	
Ø0.188	+0.005/-0.001	.191	2		✓	
0.300	+/-0.010	.305	✓		✓	
0.300	+/-0.010	.306	2		✓	
0.038	+/-0.010	.037	1		✓	

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	12-3-09	Date:	12/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	AS

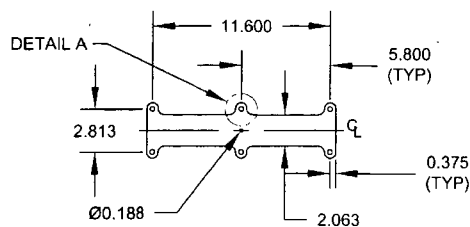
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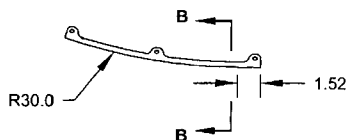
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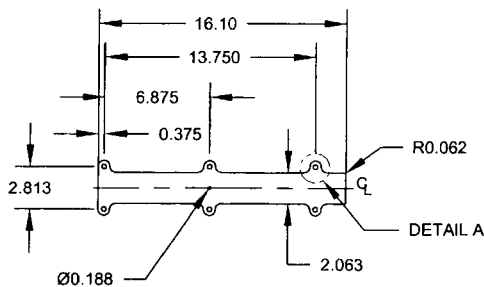
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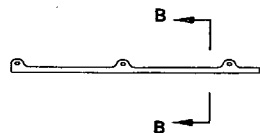
D3508-1 FLAT PATTERN



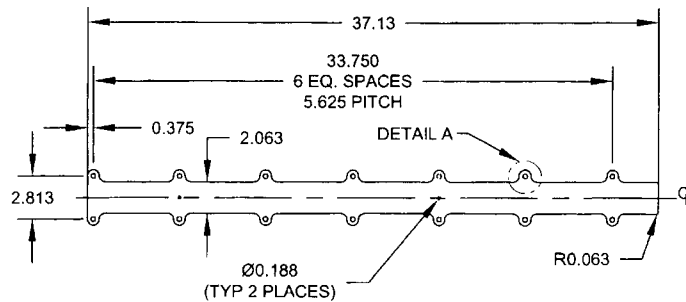
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



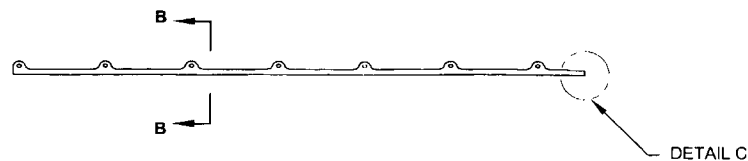
D3508-7F FLAT PATTERN



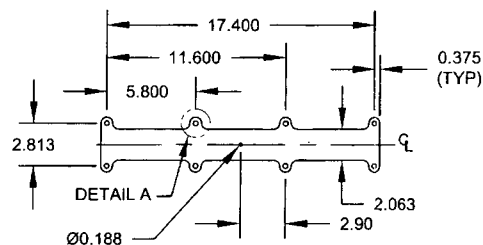
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(MAKE FROM D3508-7F)



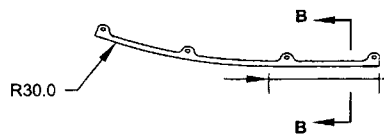
D3508-3 FLAT PATTERN



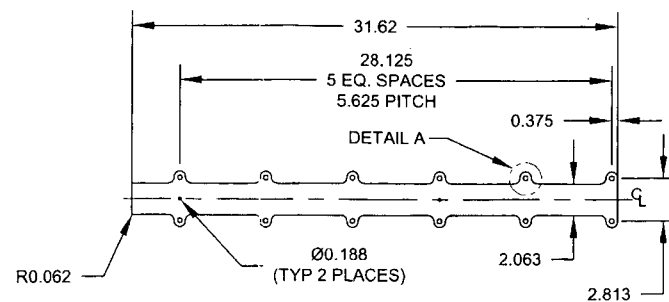
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



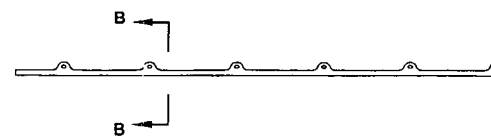
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 01345 HCV
12/03/13

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3508
REV. C
SHEET 1 OF 2

TITLE WEARPLATE
SCALE 1:8

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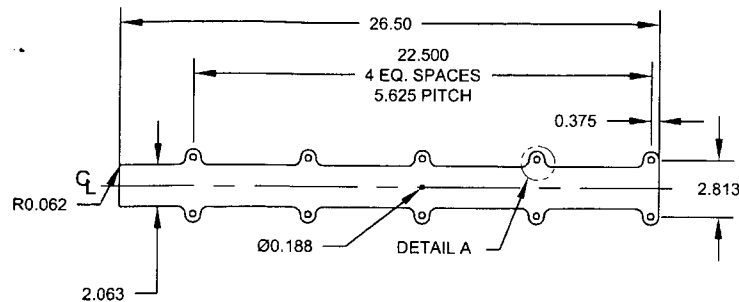
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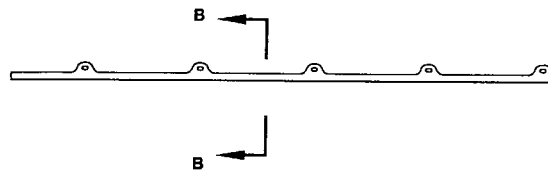
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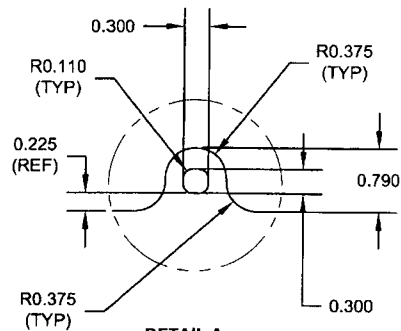
NOTE: Date & initial all entries



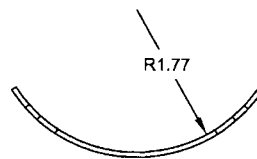
D3508-11F FLAT PATTERN



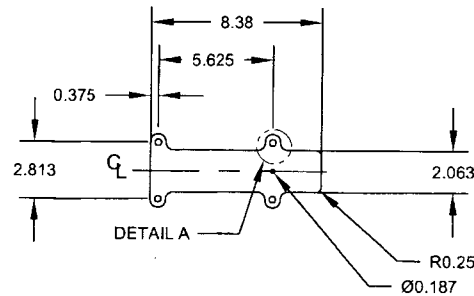
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



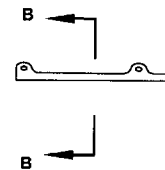
DETAIL A
(SCALE 2:3)



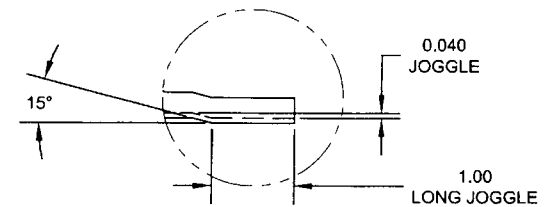
SECTION B-B
(SCALE 2:3)



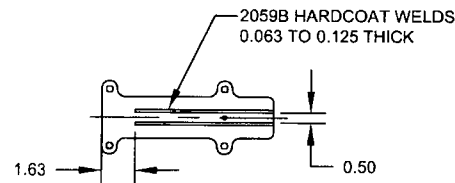
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07/11/16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. D3508	REV. C
MFG. APPR.	PH	SHEET 2 OF 2	
APPROVED	PH	TITLE WEARPLATE	
DE APPR.	PH	SCALE 1:6	
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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